

Work Order ID 94450

94450

Page 1

December-19-12 10:46:31 AM

Item ID: D044-662-011

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Bearpaw

Stop *NS2*

Start Date: 12/19/12

Start Qty: 1.00

1

Cust Item ID:

Required Date: 1/11/13

Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: MLS

Date: 12-12-12

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3075	Rev B								
100		0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Document Control	Photocopy bluefile & type labels per PPPD044-662-011 CHG003								
110		0.00							
110	QC4- 100% inspect kits for completeness								
QC	Memo	0.00							
Quality Control									
120		0.00							
120	Packaging								
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D044-662-011								
	Location: FG 013								
	REV-C								

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data <input type="checkbox"/>											
Equip/Tooling <input type="checkbox"/>											
Operator <input type="checkbox"/>											
Material <input type="checkbox"/>											
Setup <input type="checkbox"/>											
Other <input type="checkbox"/>											
Process <input type="checkbox"/>											
Supplier <input type="checkbox"/>											
Training <input type="checkbox"/>											
Unapproved <input type="checkbox"/>											
FAULT CATEGORY											
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped. <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube			General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio			<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions			<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other		

Work Order ID 94450***94450***

Page 2

December-19-12 10:46:31 AM

Item ID: D044-662-011

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bearpaw

Start Date: 12/19/12 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 1/11/13 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC21- Final Inspection - Work Order Release	0.00							
130									
QC	Memo	0.00							
Quality Control									

13/1/28
11301-21

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data <input type="checkbox"/>											
Equip/Tooling <input type="checkbox"/>											
Operator <input type="checkbox"/>											
Material <input type="checkbox"/>											
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Other <input type="checkbox"/>											
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Picklist Print

January 22, 2013 7:48:43 AM

Page 1

Work Order ID: 94450
Parent Item: D044-662-011
Parent Item Name: Bearpaw

Start Date: 12/19/12
Start Qty: 4.00

Required Date: 1/11/13
Required Qty: 4.00

Comments: IPP Rev:C04.02.19 Added tolerance and ref to DSK086-12 to Step 3KJ/JLM
IPP Rev:D As per ECN 932 & 862 06-07-28 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3075-1 R44 Bearpaw		Manufactured	No			110	Each	1.0000	2	8			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST269									
				71924									
D216-1 Rubber Cushion		Manufactured	No			110	1	373.0000	0.93	3.72			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST412		373							
				86201		23							
				93429		350							
D2529 Washer		Manufactured	No			110	Each	382.0000	8	32			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST011		382							
				79485		16							
				92045		266							
				95164		100							
D3556-1 Clamp		Manufactured	No			110	Each	7.0000	4	16			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST457		7							
				51405		1							
				81364		6							

5MP
4

4x4.5" 5MP 4

5MP 4

5MP 4

94624

SP

3.72

SP

32x

94217

Picklist Print

January 22, 2013 7:48:43 AM

Page 2

Work Order ID: 94450

Parent Item: D044-662-011

Parent Item Name: Bearpaw

Start Date: 12/19/12

Required Date: 1/11/13

Start Qty: 4.00

Required Qty: 4.00

D3601-1
Radius Block

Manufactured No

110 Each 76.0000

8 32 SP

Smp 4

Location	Loc Qty	Loc Code
ST059	76	
82748	6	
83314	46	32x
94787	24	

AN414A
Bolt

Purchased No

110 Each 1,392.0000

4 16 SP

Smp 4

Location	Loc Qty	Loc Code
FG	5	
122141	5	
ST357	37	
115374	1	
123352	36	12x
ST514	750	
123900	150	4x
124215	600	
ST517	600	
124221	600	

AN415A
Bolt

Purchased No

110 Each 701.0000

4 16 SP

Smp 4

Location	Loc Qty	Loc Code
GA	100	
120449	100	
ST357	1	
123900	1	
ST514	600	
123525	200	
124221	400	

AN960JD416
Washer

NAS1149D0463J Purchased

No

110 Each 0.0000

8 32 11/24/98 SP 13-01-23

Smp 4

January 22, 2013 7:48:43 AM

Shop Packet Print

Page 2

Picklist Print

January 22, 2013 7:48:43 AM

Work Order ID: 94450
 Parent Item: D044-662-011
 Parent Item Name: Bearpaw

Start Date: 12/19/12

Required Date: 1/11/13

Start Qty: 4.00

Required Qty: 4.00

MS2104214

Purchased

No

110

Each

6,710.0000

8

32

SP13-01-23

Nut

Sm 4D

Location

Loc Qty

Loc Code

FP001

318

122452

306

8182

12

FP-001

12

8182

12

GA

221

121444

221

ST314

1659

119017

20

123248

900

123355

739

ST506

1500

123900

1500

ST518

3000

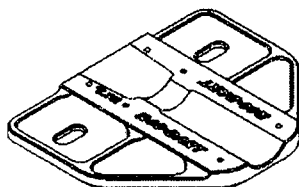
124231

3000

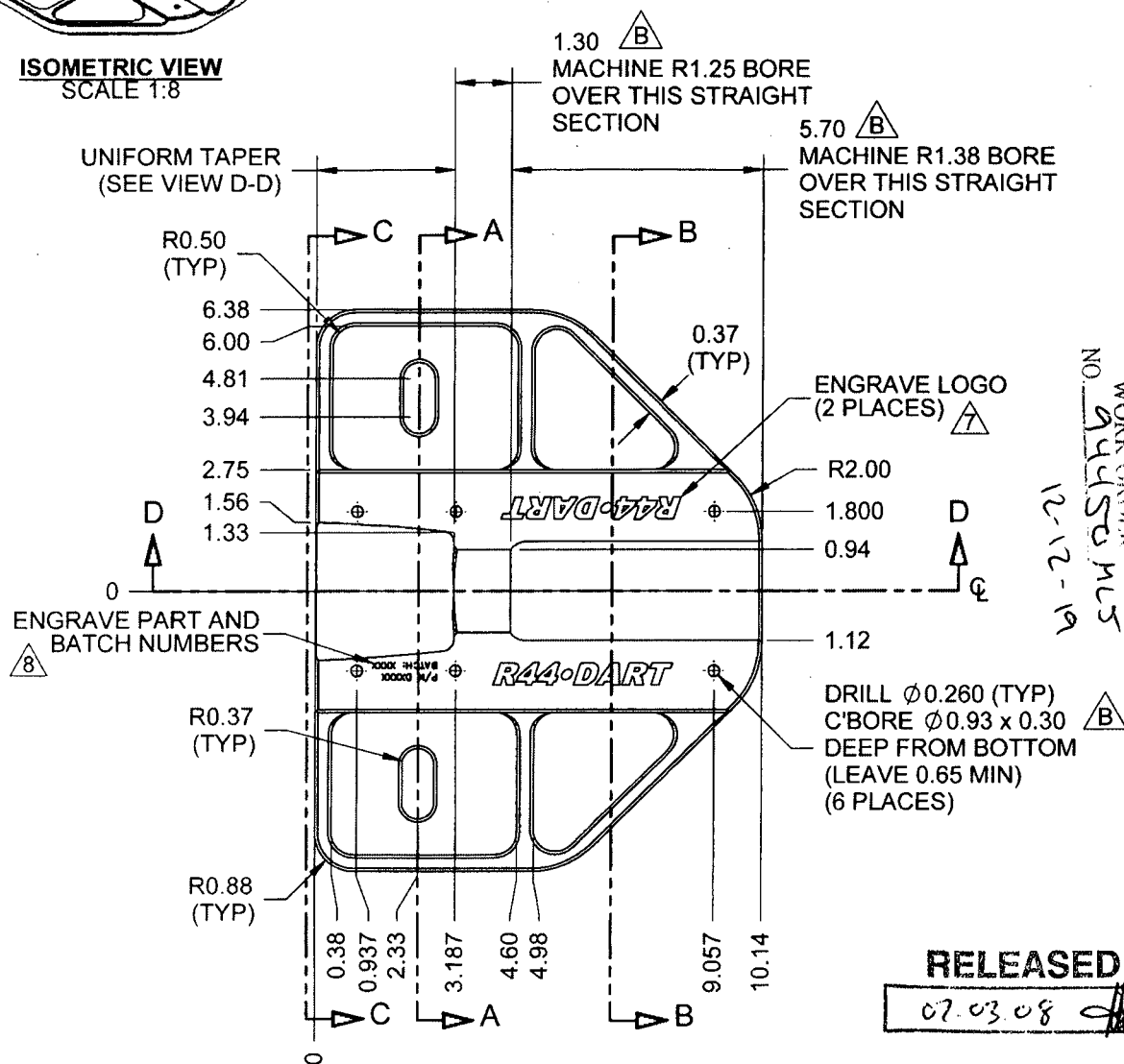
32x



DESIGN #1	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #1	APPROVED #1	DRAWING NO. D3075	REV. B SHEET 1 OF 2
DATE 07.02.27	TITLE R44 BEARPAW		SCALE 1:4
REV A	DATE 02.01.04	DESCRIPTION NEW ISSUE	
B	07.02.27	1.30 WAS 1.60; 5.70 WAS 5.84; Ø 0.93 WAS Ø 0.75; ADD QTY(2) HOLES AT (0.937, ±1.800)	



ISOMETRIC VIEW
SCALE 1:8



D3075-1 BEARPAW

NOTES:

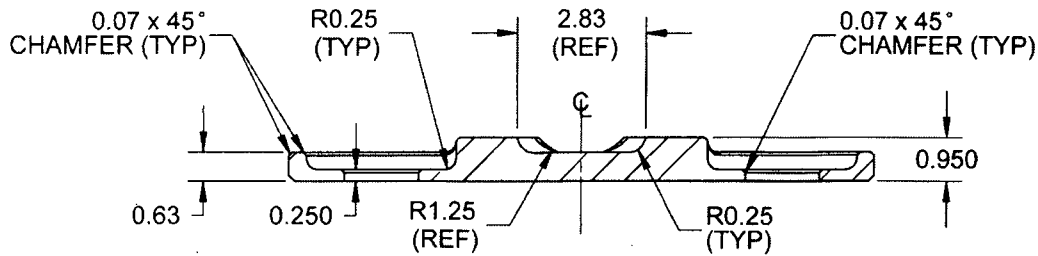
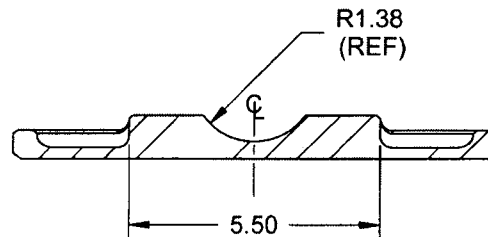
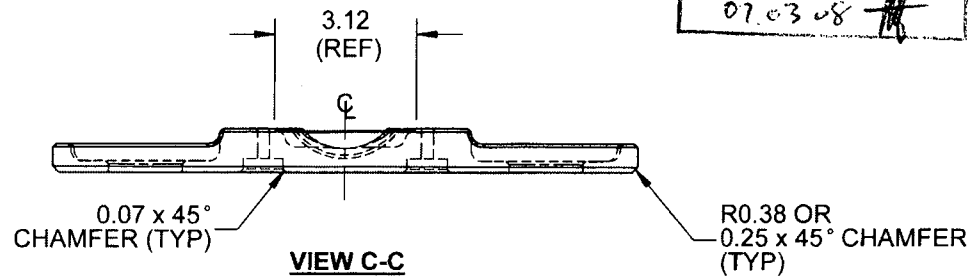
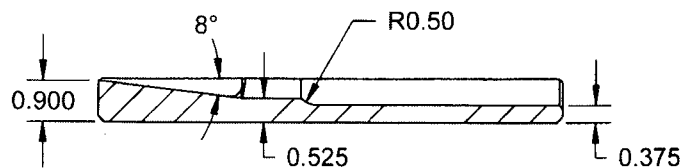
- 1) MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689, 1.00 THICK (MACHINE TO 0.950)
- 2) FINISH: NONE
- 3) PART IS SYMMETRIC ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) ENGRAVE LOGO TO MAX DEPTH OF 0.012 AT LOCATION SHOWN
- 8) ENGRAVE PART AND BATCH NUMBERS TO MAX DEPTH OF 0.010 AT LOCATION SHOWN

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DART

DESIGN #	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED B	APPROVED H	DRAWING NO. D3075	REV. B SHEET 2 OF 2
DATE 07.02.27		TITLE R44 BEARPAW	SCALE 1:4

**SECTION A-A****SECTION B-B****VIEW C-C****SECTION D-D****RELEASED**

07.03.08

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94150

Smf

5.0 PARTS LIST

Qty -011	Qty -013	Qty -041	Part Number	Description
X			D044-662-011	BEARPAW INSTALLATION
	X		D044-662-013	BEARPAW INSTALLATION
		X	D044-662-041	WEARPLATE KIT
4	4		D2182B045	Rubber Cushion
		4	D2274	Radius Block
8	8	4	D2529	Washer
2			D3075-1	Bearpaw
	2		D3529-1	Bearpaw
4	4		D3556-1	Clamp
		4	D3565-1	Wearplate
8	8		D3601-1	Radius Block
		4	AN4-12A	Bolt
4	4		AN4-14A	Bolt
4	4		AN4-15A	Bolt
		4	AN4-16A	Bolt
8	8		AN960JD416	Washer
8	8	4	MS21042L4	Nut (or MS21042-4)

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Revision: D

Date: 07.02.14